

Date: Friday, 13/02/2009 1:02:23 PM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	ARM
Job Number	45787	Part Number	D27952
Estimate Number	11737	Drawing Number	D2795 REV A
P.O. Number		Project Number	N/A
This Issue	13/02/2009	Drawing Revision	A
Prsht Rev.	NC	Material	
First Issue	/ /	Due Date	20/02/2009
Previous Run	33588	Qty:	4
Written By		Um:	Each
Checked & Approved By	JUL 09/02/13		
Comment	Est: A 01.02.05 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B0500X06000	6061-T6 Bar .500 x 6.00	
	Comment: Qty.: 1.3913 f(s)/Unit Total : 5.5650 f(s) 6061-T6 Bar .50" x 6.0" Material: 6061-T6 (QQ-A-200/8) 0.500" thick (M6061T6B0.500x06.000) Identify for D2795-2 Batch: M110912	Mat not in computer J.A 09/02/20	(4)
2.0	BAND SAW	BAND SAW	
	Comment: BAND SAW Cut blanks 15.800" long	J.A 09/02/20	(4)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA106 Tumble & Deburr	JL / 09/02/21	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JL / 09/02/21	
5.0	QC8	SECOND CHECK	
	Comment: SECOND CHECK	88 09/02/23	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/02/2009 1:02:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 45787

Part Number: D27952

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST151

AS 09/02/23 (x4)

7.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	45787
Description: Arm	Part Number:	D2795-2
Inspection Dwg: D2795	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

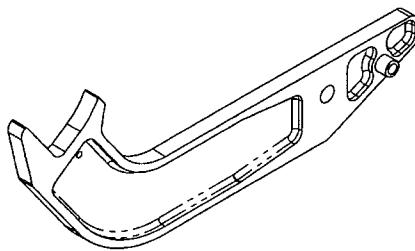
X First Article Prototype

✓ 998

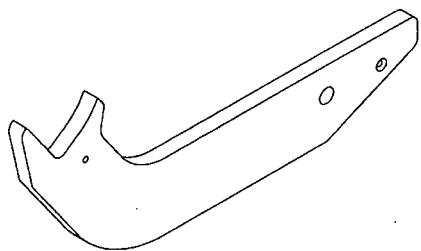
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/02/21	Date:	09/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF ✓	✓

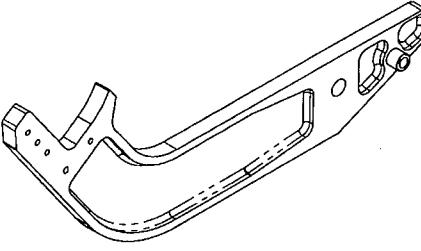
ITEM NO.	QTY. 041	QTY. 042	QTY. 043	QTY. 044	PART NUMBER	DESCRIPTION
1	X				D2795-041	ARM ASSEMBLY
2		X			D2795-042	ARM ASSEMBLY
3			X		D2795-043	ARM ASSEMBLY
4				X	D2795-044	ARM ASSEMBLY
11	1				D2795-1	ARM
12		1			D2795-2	ARM
13			1		D2795-3	ARM
15				1	D2795-4	ARM
21	1	1	1	1	D2808	SPACER



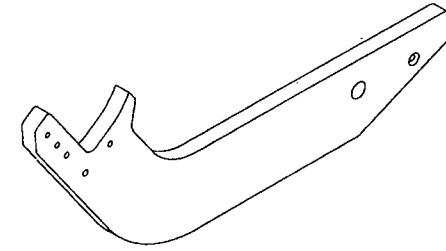
D2795-041 ARM ASSEMBLY



D2795-042 ARM ASSEMBLY



D2795-043 ARM ASSEMBLY



D2795-044 ARM ASSEMBLY

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 45281

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2795-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D2795-041/042 1.22 lbs
D2795-043/044 1.29 lbs

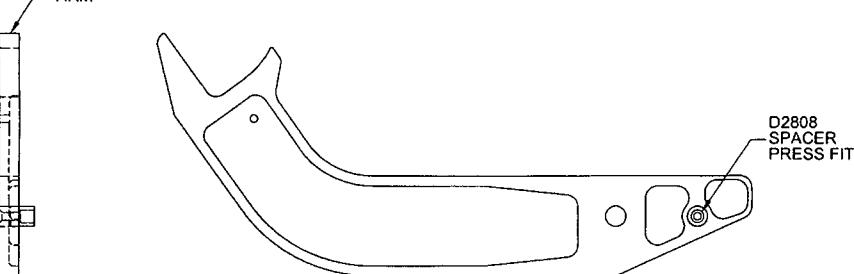
B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. -1 & -2 PARTS HAD NO PHYSICAL CHANGES BUT WERE REDIMENSIONED. SEE PREVIOUS REV FOR DETAILS. -043, -044 -3 & -4 ADDED. MATERIAL SPECS UPDATED.		AJS	08.10.21
A	NEW ISSUE		DS	00.11.03
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	<i>b</i>	REV. B DRAWING NO. D2795		
MFG. APPR.	<i>b</i>	SHEET 1 OF 5 APPROVED		
DE APPR.	<i>b</i>	TITLE ARM ASSEMBLY		
DATE	08.10.21	SCALE NTS		

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8 7 6 5 4 3 2 1

D

D2795-1
ARM



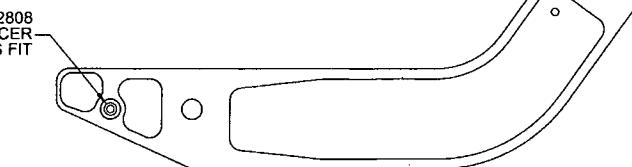
C

D2795-041 ARM ASSEMBLY

D

D2795-2
ARM

D2808
SPACER
PRESS FIT

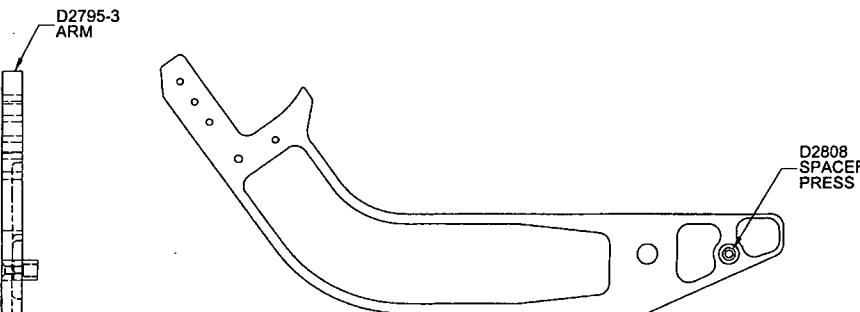


C

D2795-042 ARM ASSEMBLY

B

D2795-4
ARM

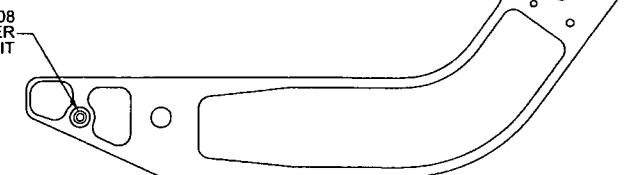


B

D2795-043 ARM ASSEMBLY

△

D2808
SPACER
PRESS FIT



A

D2795-044 ARM ASSEMBLY

△

RELEASED
09/01/21 MB

WORK ORDER
NO 45287
WITHOUT NOTICE
SHOP COPY
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ENGINEERING
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SUBJECT TO AMENDMENT

DESIGN	DS	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	△	DRAWING NO.
MFG. APPR.	△	D2795
APPROVED	△	REV. B
DE APPR.	△	SHEET 2 OF 5
DATE	08.10.21	TITLE
		ARM ASSEMBLY
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